

# Work Order ID 78267

January-04-12 10:51:51 AM

**\*78267\***

Page 1

Item ID: D2976 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: BO 105 Skidtube I Beam  
 Start Date: 04/01/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 06/01/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>  |                      |         |        |              |               |               |                  |                |
| D2976                          | Rev A1   |                      |         |        |              |               |               |                  |                |
| 100                            | Skidtubes  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |  |                      |         |        |              |               |               |                  |                |
| Skidtubes                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Skidtubes                      | Cut D2963-084 extrusion to length: (82.00")Use Jig DT8546 to drill pilot holesOpen holes to finish size per dwg D2976Debur |                      |         |        |              |               |               |                  |                |
| 110                            | Chemical Conversion Coat per QSI005 4.1  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |  |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |  |                      |         |        |              |               |               |                  |                |
| 120                            | QC5- Inspect part completeness to step on W/O  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

2 B 12/01/04

Ae 12/01/04

DP 12-1-5

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 78267

**\*78267\***

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January-04-12 10:51:51 AM

Item ID: D2976

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: BO 105 Skidtube I Beam

Start Date: 04/01/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: **46**

0.00

**DP**

**12-1-5**

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

**CK 12/01/06.**

**ME 12-01-05**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-04-12 10:51:55 AM

Page 1

Work Order ID: 78267

**\*78267\***

Parent Item: D2976

**\*D2976\***

Parent Item Name: BO 105 Skidtube I Beam

Start Date: 04/01/2012

Required Date: 06/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C02.10.30Re-formatKJ

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|           |  |              |    |  |  |     |      |         |   |   |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2963-084 |  | Manufactured | No |  |  | 110 | Each | 89.0000 | 1 | 2 |  |  |  |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

**\*D2963-084\***

Extrusion

\*\*

2  
2

B

12/01/04

Location

HALL

Loc Qty

89

89

Loc Code

14459

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

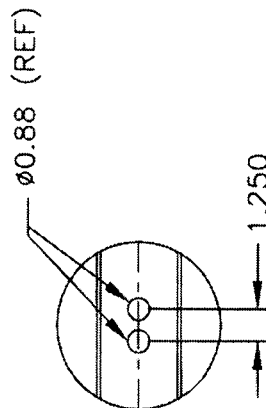
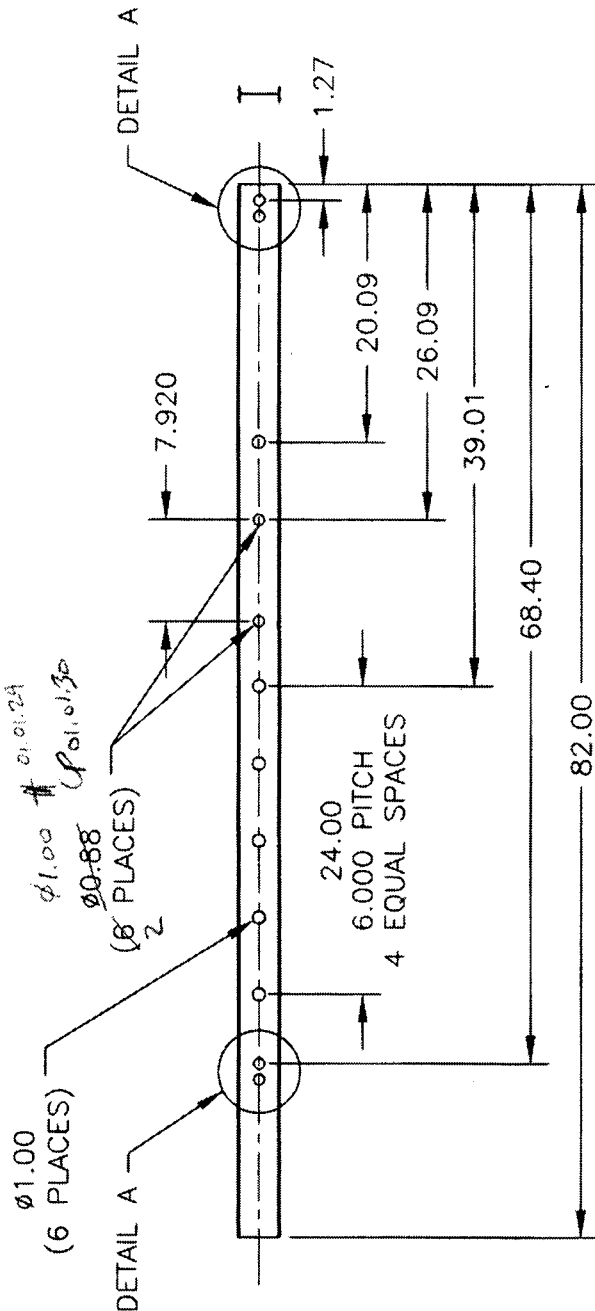
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>RF     | DRAWN BY<br>RF | DART AEROSPACE USA, INC.<br>BELLEVUE, WA  |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2976                      | REV. A<br>SHEET 1 OF 1 |
| DATE<br>00.03.14 |                | TITLE<br>WEB                              | SCALE<br>1:14          |
| A                | 00.03.14       | NEW ISSUE                                 |                        |
| A1               | 01.01.29       | OPEN GROUND HANDLING HOLES TO $\phi 1.00$ |                        |

RELEASED  
00.05.11 #



UNCONTROLLED COPY  
SUBJECT TO RECALL  
DATE 7/8/2007 BY M.L.S.  
12/01/04

MAKE FROM D2963-084 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                       |                          |
|------|------|--------------------|----|------|-----|---------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod. Mgr. | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                       |                          |
|      |      |                    |    |      |     |                                       |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries